

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007744**Date Inspected:** 25-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2:

1AAE

Caltrans QA inspector was notified by ABF QC Kelvin Cheung that ZPMC would start removal of internal stiffeners on OBG Segment 1AAE at locations, A00 (3 stiffeners) and A41 (6 stiffeners) for correction of deformation of the edge plates. This QA inspector observed ZPMC personnel removing plates with oxyacetylene cutting, Air Carbon Arc cutting and then grinding the weld flush with the parent material.

Bay 2-

FCAW welding of weld joint 055 located on Floor Beam, FB020-005. ZPMC welder was identified as 048433. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

Bay 6-

SMAW welding of weld joints 010, 011 located on 131 meter double diaphragm WSD1-DPSA4-2 B/B. ZPMC

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

welders were identified as 068091 and 037932 . ZPMC QC is identified as Wu Ming Kai. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3312-TC-P5.

FCAW repair welding of weld joints 135 located on OBG Segment 8BW at Panel point 67 . ZPMC welders was identified as 0055491 . ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-3G (3F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
